

Work Order ID 107793

Wednesday, October 02, 2013 10:19:55 AM

647.5711
B 107793

107793

Page 1

Item ID: 647.5711

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Shim

Stop

NS2

Start Date: 10/2/2013 Start Qty: 12.00

12

Cust Item ID:

Required Date: 10/11/2013 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: MF

Date: 13-10-02

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
647.5700	N/C

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

6061.063

Dwg Rev: N/C

SHIM STOCK!

Prog Rev: N/C

2-Deburr if necessary

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

DAS
27
9-89

13 10 20

25
12

0

Jm 13-10-12

25
12

0

Jm 13-10-12

PTU

~~LAST PAGE~~

25
12

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Am Date: 13/11/05QA Closed: Am Date: 13/11/01

Work Order: <u>107793</u>	DISPOSITION Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS			
Part No. <u>647.5711</u>		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input checked="" type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. <u>13-31910</u>		Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	13-10-22	100	12x	Used wrong material. - Use 6061-T6 SHIM STOCK. Re operator error did not pay att Re operator did not understand what Shim stock was - LACK of TRAINING	S 13 6 9-89 052042 13/10/22	Scrap + destroy	Am 13-10-22 \$8.09	13-10-22 13/10/22	DAS 16 9-89 13/10/30 052042
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training	<input checked="" type="checkbox"/>								
Unapproved									

FAULT CATEGORY.			
Landing Gear			
<input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input checked="" type="checkbox"/> Other
Employee was not trained correctly on what type of material to use.			

Work Order ID 107793

107793

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Wednesday, October 02, 2013 10:19:55 AM

Item ID: 647.5711

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Shim

Stop *NS2*

Start Date: 10/2/2013 Start Qty: 12.00

12

Cust Item ID:

Required Date: 10/11/2013 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Identify as per dwg & Stock Location: *Russ*

0.00

150

Packaging

Memo

0.00

Packaging

25x *DAS*
28
9-89 *13-10-22*

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

13/10/31 *[Signature]*

13-10-28

Picklist Print

October-17-13 7:42:14 AM

Page 1

Work Order ID: 107793

Parent Item: 647.5711

Parent Item Name: Shim

Start Date: 10/02/13

Required Date: 10/11/13

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A 13.09.03 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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9574K68

Purchased

No

Each

24.0000

12 ?

Shim

Jm13-10-18

Location

Loc Qty

Loc Code

water jet

24

m126995

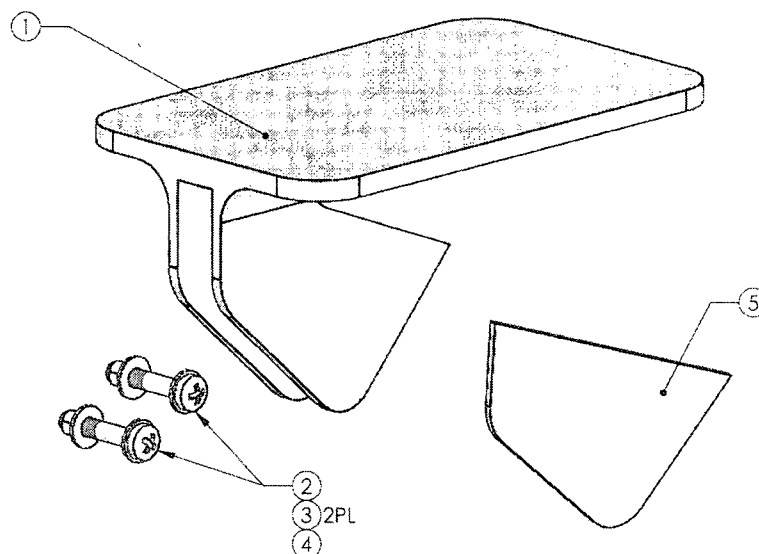
24

126995





* Used 2 S.F. of material.


REVISIONS			
REV.	DESCRIPTION	DATE	APPROVAL
	LAST PROTOTYPE DE VISION PRO		NIC
NIC	FINAL RELEASE	11/06/09	P. LEAVY

1. MATERIAL: 6061-T6 ALUMINUM PER AMS-QQ-A-200/8
2. FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III CLASS 2.
COLOR BLACK; CARDINAL 4860-50 PRETREATMENT PRIMER;
PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX
3. MATERIAL: LAMINATED ALUMINUM 1100 ALLOY SHIM STOCK
LAYER THICKNESS: .003"
FINISH: NONE
VENDOR: MCMMASTER-CARR P/N 9574K68
4. DEBURR AND BREAK ALL SHARP EDGES
5. IDENTIFY IAW MPP-120



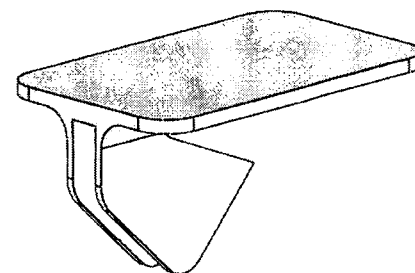
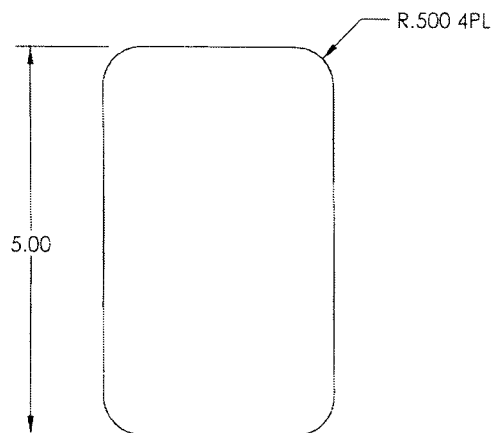
647.5701 GPS MOUNT KIT

		1	5	601.5711	SHIM			
		2	4	601.2973	LOCKNUT		NAS21042 CB	
		4	3	601.2764	WASHER		NAS31494B2P	
		2	2	601.3081	SCREW		NAS27033-0614	
		1	1	647.5710	GPS MOUNT			
				647.5707	GPS MOUNT KIT			
		ASST	FIND #	PART #	DESCRIPTION		MAT'L	SPEC.

QTY	PARTS LIST	
NEXT ASSY IS:	<div> <div> ORIGINAL DATE DRAWN BY D DATE DESIGNED APPROV. E DATE 11/10/09 CHECKED D DATE 11/10/09  </div> <div> APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760)724-5300 GPS MOUNT KIT 7647.5700 </div> </div>	

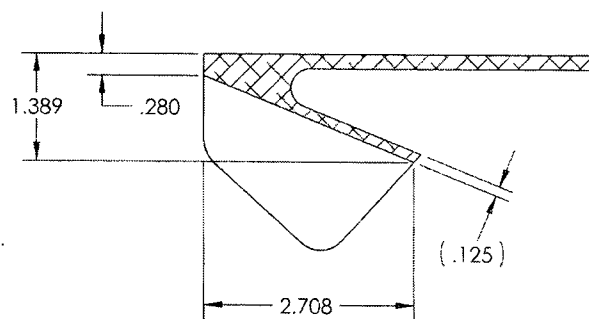
JULES CHEMICAL SPECIALTIES CHEMICALS AND EQUIPMENT 2500 WILSON AVE PLAZA DE COMERCIO #201 ANGLE 1, 5 PLAZA DE COMERCIO #206 ANGLE 1, 5	SHEET NO. 1 OF 1 SCALE NONE DATE 11/10/09
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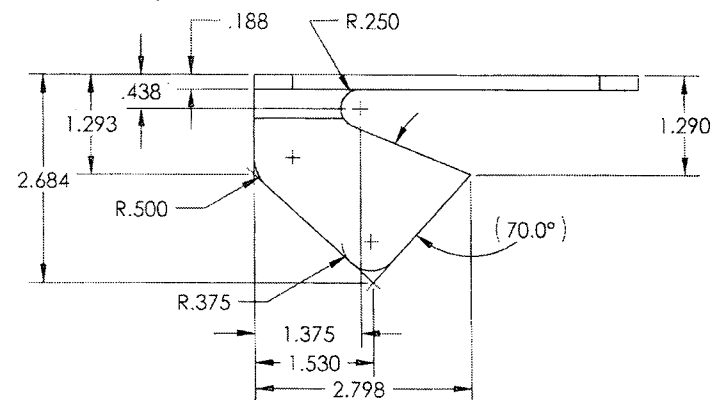
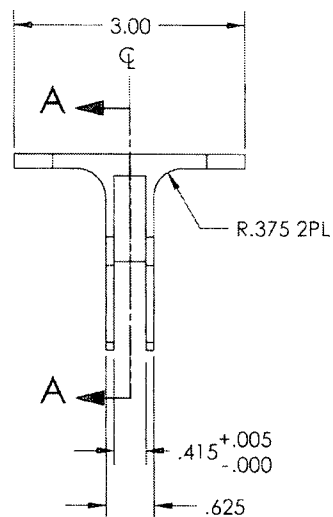


647.5710

#107793



SECTION A-A

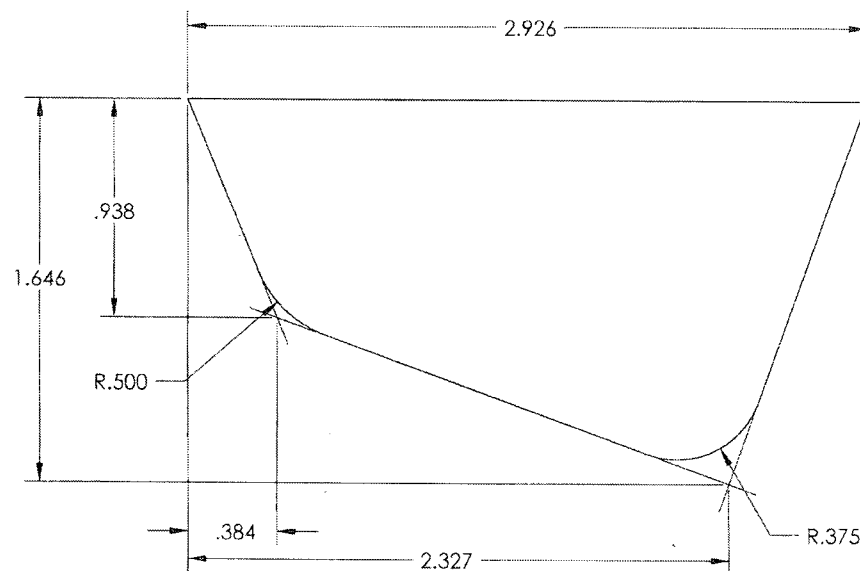


OPERATOR DATE (SHEET NAME)		11-10-09	
DRAWN BY		P. ECKERT	
CHECKED BY		D. ECKERT	
DRAWING APPROVAL		D. ECKERT	
DESCRIPTION		GPS MOUNT KIT	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS DECIMALS ANGLES		NET CAGE CODE B 07M15	QTY REQ 647.5700 N/C
SCALE: NONE		SHEET 2 OF 3	

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED

6061.063(T65)
STAIN STOCK.



.063

107793

647.5711

ORIGINAL DATE 11-10-01		APICAL INDUSTRIES	
DRAWN BY D. BAKER	CHECKED D. BAKER	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL BY DATE		GPS MOUNT KIT	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS .005 ANGLES ± .5°		SIZE B	REV N/C
CAGE CODE D7M26		DWG. NO. 647.5700	SHEET 3 OF 3
SCALE NONE			

